

Thursday, 9/21/2006 3:24:06 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28692
Estimate Number : 12292
P.O. Number : *NIA*
This Issue : 9/21/2006 S.O. No. : *NIA*
Prsht Rev. : NC
First Issue : *NIA* Type : PURCHASED PARTS
Previous Run : 28401
Written By : *[Signature]*
Checked & Approved By : *[Signature] 06 09.21*
Comment : est rev. A 06/02.15 new issue EC

Drawing Name : PLUG
Part Number : D26513
Drawing Number : D2651 REV.B
Project Number : N/A
Drawing Revision : B
Material : *NIA*
Due Date : 10/3/2006 Qty: 300 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *2112*

Purchase P/N: 2-008 as per Dwg D2651

Supplier: Parker

Ensure Certificate of Conformity is attached

c 206109/25 (300)

2.0 MS28775008 O RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 300.0000 Each(s)
O RING

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3446

10/4/27 300
2060928
Q5015 (300)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5154*

206109/28 (300)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 19 Date: 06/07/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 28692

Part Number: D26513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



300

Comment: FINAL INSPECTION/W/O RELEASE

SP 02/09/08

Job Completion



U 0609-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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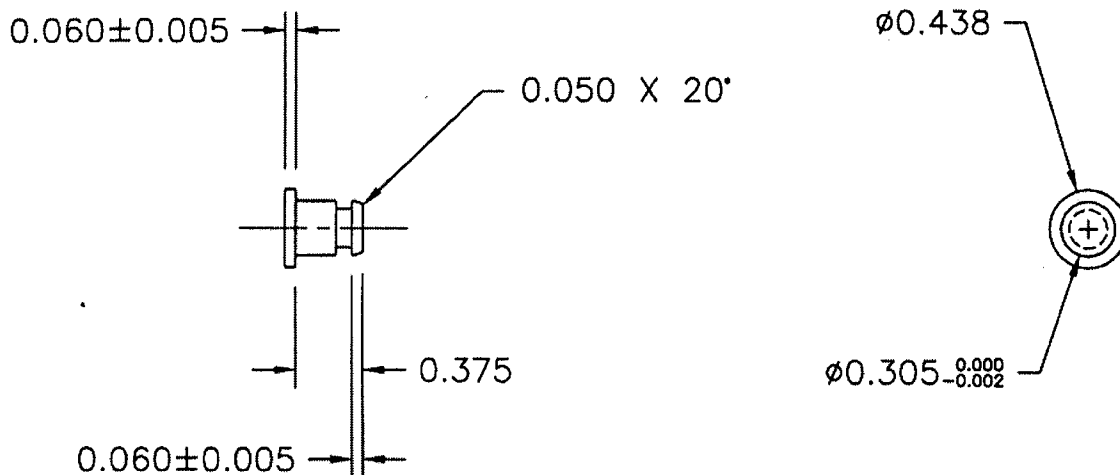
NOTE: Date & initial all entries



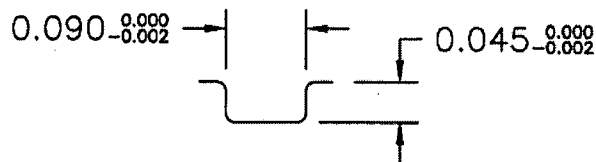
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED
03.12.19 #

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28692

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Parker Hannifin Corporation

O-Ring Division
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Brownsville, TX 78522

Phone: (859) 335-3000

--- NOTICE ---
This is a C.B.I. Compound!

C.B.I. is Parker's exclusive quality assurance program for Controlled Batch Identification, your assurance of reliability.

CONFORMANCE CERTIFICATE FOR MATERIAL SHIPPED

Parker O-Ring Division certifies that the material used in the manufacture of the parts identified below and called for on Purchase Order Number 176110 received by us from SWAN ENGINEERING & SUPPLY is traceable to C.B.I. Number 80024701 and that the material used conforms to the requirements of the specifications indicated below. The tests were performed in accordance with these specifications, and data supporting the indicated results are on file.

CUSTOMER PART NUMBER	PARKER PART NUMBER	COMPOUND	QUANTITY	CURE DATE	SHIP DATE
MS28775-008.	2-008	N0304 -75	10000	3Q04	10/07/04
TESTED AS: 2-214					
PHYSICAL PROPERTIES		REQUIREMENTS	VARIATION	PARKER FINDINGS	
SPECIFICATION MIL-P-25732C		TYPE	CLASS	TEST DT 09/04/04	
ASTMD297 SPECIFIC GRAVITY				(1.26 - 1.30)	1.2800
ASTMD2240 HARDNESS SHORE A			(68 - 80)	(70 - 80)	75
ASTMD1414 TENSILE STRENGTH, PSI			1350 MIN	(1440 - 2160)	1916
ASTMD1414 ELONGATION, %			160 MIN	(160 - 226)	225
MODULUS AT 100% ELONG.			500 MIN	(500 - 9999)	545
TR-10 50% ELONG. 10% RETURN			-49 MAX		-53.0
FLUID AGEING 70 HRS AT 275F IN MIL H-5606					
ASTMD395 COMPRESSION SET % MAX			55		33.3
TR-10			-49 MAX		-53.0
ASTMD2240 HARDNESS CHANGE			+5 -15		-12.0
VOLUME CHANGE			-20		18.8

No Mercury, Mercury compounds or Mercury bearing instruments, equipment or apparatus which might cause contamination has been used in the manufacture or subsequent processing of material covered by this order.

Purchaser use only. Reproduce only in full. Data pertains to items referenced.

The recording of false, fictitious or fraudulent statements or entries on the certificate may be punishable as a felony under federal law.

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O-Ring Division
PARKER HANNIFIN CORPORATION

By

Ruben Ramirez
Quality Assurance Manager